

Date: Thursday, 2/14/2008 10:57:47 AM
 User: Kim Johnston

Process Sheet

Customer	CU-DAR001 Dart Helicopters Services		Drawing Name	BRACKET		
Job Number	37435					
Estimate Number	10283					
P.O. Number				Part Number	D31991	
This Issue	2/14/2008	S.O. No.	:	Drawing Number	D3199 REV B	
Prsht Rev.	NC			Project Number	N/A	
First Issue	:	/ /	Type	SMALL /MED FAB	Drawing Revision	B
Previous Run	36631			Material	:	
Written By	<u>10/08/02/14</u>			Due Date	3/10/2008	Qty: 60 Um: Each
Checked & Approved By						
Comment	Est Rev:C	Removed Scribing	05-11-05	JLM		
	Est Rev:D	As per Rev B	06-11-24	JLM		

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
1.0	M304S20GA	.304/316 .040 Sheet 7
		Comment: Qty.: 0.1040 sf(s)/Unit Total : 6.2370 sf(s) 304/316 0.040" SHEET Batch: <u>106748</u> HB 8-2-21
2.0	WATER JET	FLOW WATER JET
		Comment: FLOW WATER JET Cut as per Dwg D3199 Dwg Rev: <u>B</u> HB 8-2-21 Prog Rev: <u>B</u> 65
		Deburr if required HB 8-2-21
3.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE HB 8-2-21 66
		Comment: INSPECT PARTS AS THEY COME OFF MACHINE
4.0	QC8	SECOND CHECK 10602-25 66 counted
		Comment: SECOND CHECK
5.0	SMALL FAB 1	SMALL & MEDIUM FAB RESOURCE 1
		Comment: SMALL & MEDIUM FAB RESOURCE 1 Form as per dwg D3199 SB 08/02/2008 66

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: Date: 06/02/27
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Thursday, 2/14/2008 10:57:48 AM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: BRACKET

Job Number: 37435

Part Number: D31991

Job Number:



Seq. #: Machine Or Operation:

Description :

6.0 QC5

INSPECT WORK TO CURRENT STEP



Fac00227 (66)



Comment: INSPECT WORK TO CURRENT STEP

7.0 POWDER COATING

POWDER COATING



m106442



Comment: POWDER COATING

POWDER COATING

Powder Coat Gey Sandtex (Ref: 4.3.5.7) as per QSI 005 4.3

Fd 08/02/27 (66)

8.0 QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

M-1 08/02/27

9.0 PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock
Location: _____

87234A

Fac00227 (66)

(66)

10.0 QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

No final/27

Job Completion



mi 2008/2/27

(66)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART AEROSPACE LTD	Work Order:	37435
Description: Bracket	Part Number:	D3199-1
Inspection Dwg: D3199 Rev: B		Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

X First Article Prototype

Graph of $y = \sin x$

Measured by:	B	Audited by:		Prototype Approval:	N/A
Date:	8-2-21	Date:	6/6/25	Date:	N/A

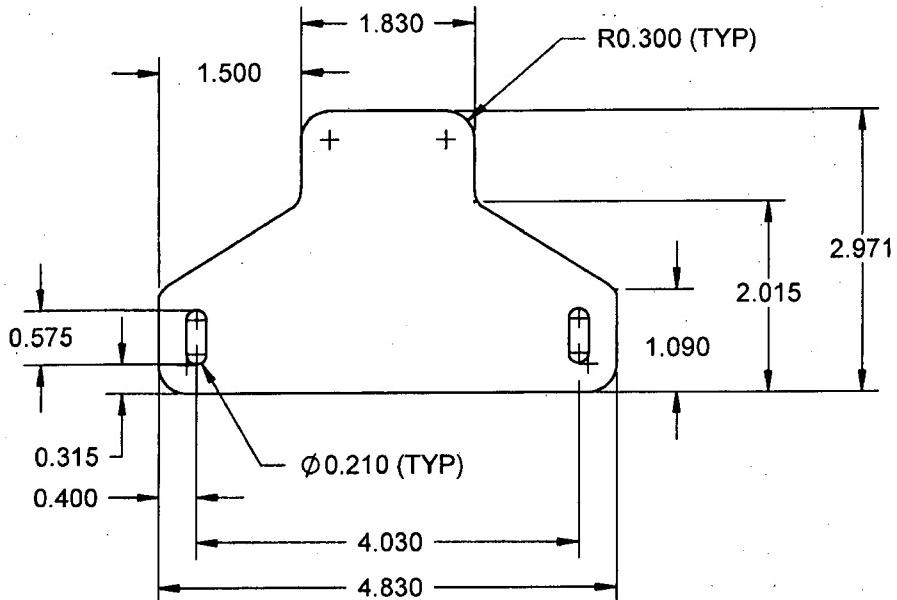
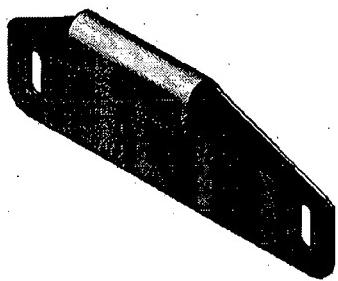
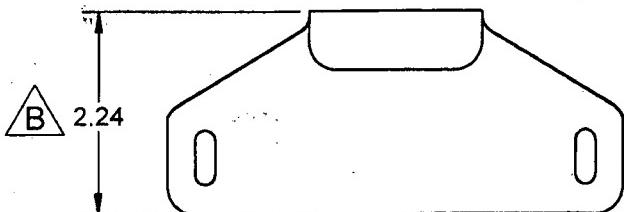
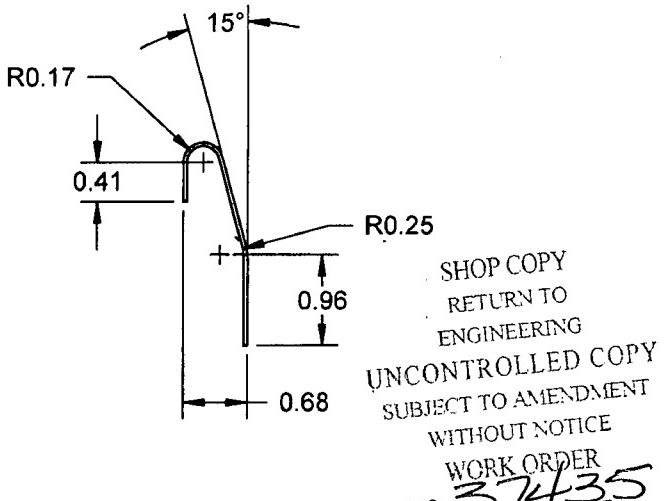
Rev	Date	Change	Revised by	Approved
A	06.10.20	New Issue	KJ/JLM	
B	06.11.24	Dwg Revision revised	KJ/JLM	Z

DART

DESIGN <i>QP</i>	DRAWN BY <i>CB</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA
CHECKED <i>CE</i>	APPROVED <i>SH</i>	DRAWING NO. D3199
DATE 06.11.01		TITLE BRACKET
		REV. B SHEET 1 OF 1 SCALE 1:2

REV	DATE	DESCRIPTION
A	03.08.05	NEW ISSUE
B	06.11.01	2.24 WAS 2.142; ADD FINISH; UPDATE DWG

RELEASED

06.11.01 *SH***D3199-1 FLAT PATTERN****D3199-1 BRACKET****NOTES:**

- 1) MATERIAL: AISI 304/316 SS SHEET 0.040" THICK PER MIL-S-5059 (REF DART SPEC. M304S) ANNEALED
- 2) FINISH: POWDER COAT GREY SANDTEX (REF 4.3.5.6) AS PER QSI 005 4.3
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) IDENTIFY WITH DART P/N "D3199-1" USING FINE POINT PERMANENT INK MARKER
- 5) ALL DIMENSIONS ARE IN INCHES UNLESS OTHERWISE NOTED
- 6) BREAK ALL SHARP EDGES 0.005 TO 0.010 MAX

